

Date: Wednesday, 8/30/2006 11:56:56 AM
 User: Kim Johnston

00053

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28356
 Estimate Number : 12491
 P.O. Number :
 This Issue : 8/30/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev. New Issue 06-07-26 JLM

Drawing Name : GPS RECEIVER HOUSING
 Part Number : D35141
 Drawing Number : UNDER REVIEW CB 06.08.30
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 9/6/2006 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.4812 sf(s)/Unit Total : 0.4812 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M1007427

M 06 08 30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: Prel

Prog Rev: Prel

Ensure Grain Direction is correct**

2-Deburr if necessary

M 06 09 07

①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 09 07

①

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 06.07.07

①

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Countersink as per Dwg D3514

SA 06/09/07

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.09.03	2.0	Scrap 1 piece because holes were not in tolerance with the drawing						

NOTE: Date & initial all entries

Date: Wednesday, 8/30/2006 11:56:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28356

Part Number: D35141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RE

06.09.14

①

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

SB

06.09.14

②

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RE

06.09.14

①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

06-09-14

④

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RE

06.09.14

①

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Per eng. use only.

RE

06.09.14

①

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

207103108

Job Completion



u 06-09-14

Eng Approval

CB 07.07.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

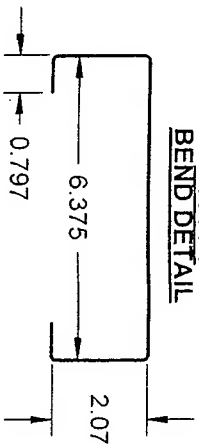
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

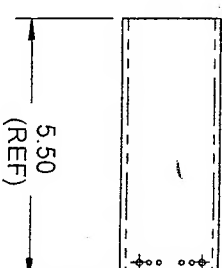
DESIGN	DRAWN BY	DART AEROSPACE LTD
CB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3514
DATE	TITLE	REV. A
06.05.03	GPS RECEIVER HOUSING	SHEET 3 OF 7
		SCALE 1:4

D3514-1
BEND DETAIL

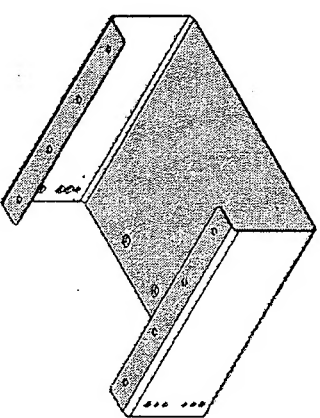
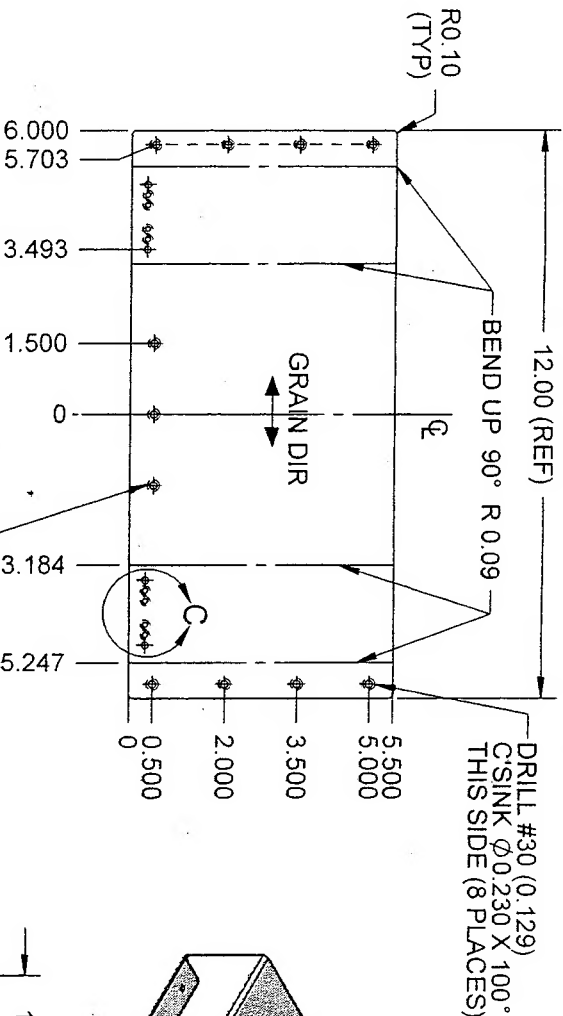


UNDER REVIEW

06.03.22 CB



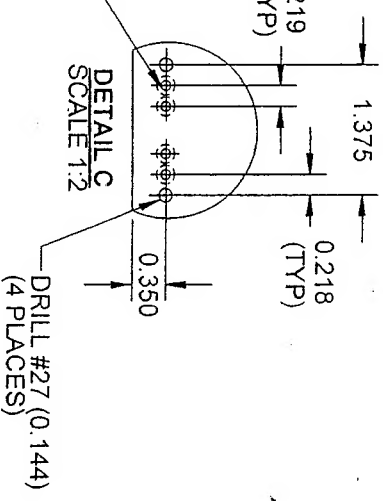
11, 813



D3514-1F
FLAT PATTERN

DRILL #30 (0.129)
C/SINK Ø0.230 X 100°
THIS SIDE (3 PLACES)

DRILL #40 (0.098)
C/SINK Ø0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET (REF. DART SPEC. (M6061T6S 040))
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT Q
- 7) C/SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28350

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WORK ORDER **		04/13/06 ORD	
DELIVERY DATE		SHIP BRANCH	WORK ORDER
04/24/06 DEL		30(04)	30-TOR UZ3809
6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y			
SHIP TO		Copper and Brass Sales Canada	
SPACE 01		A ThyssenKrupp Materials NA company	
ERDEEN ST		ThyssenKrupp	
ESBURY ON CANADA K6A 1K7			
ORDER NUMBER	TERRITORY	ENTRY ID	
000001005	01	30BXT	
NAME	INSIDE SALES		
INDA LACELLE	BRIAN TEDESCO		
TELEPHONE	INSIDE SALES TELEPHONE		
(13) 632-9577	(905) 696-8100 37622		
SHIP VIA	SHIPPING STATUS		
	COMPLETE	PARTIAL	CANCEL
	X		
STANDARD	FOB	DATE	
COMMON/FRT-CCX	DEST		
	PPD	FINISHED GOODS LOCATION	
		WARN LABEL:1001	

PART DESCRIPTION: 063496-4

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144
 DART AEROSPACE, NO PROCESSING - 48" X 144" Mill
 Dimensions., Test Results Attn to: QA Department.
 MEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL
 REFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

SPECIAL INSTRUCTIONS:

Shipping, do not place any packages or goods on top of our material."

SCRAP		FILLED BY SC		PACKED BY		Q/A AUDIT	
RECEIVED HOURS		MAX SKID WEIGHT		LOADING INSTRUCTIONS		MAXIMUM BUNDLE WEIGHT	
8-3		100		HAND, CRANE, FORK, DOCK		200	
BAKS	CASES	CUSHP	PKGS	SKIDS	BOLS	TUBS	CTNS
INSPECTION							
RECORD							

TEST RESULTS

CERTIFICATE OF COMPLIANCE
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
 The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
 (416) 244-233-5682. We hereby certify that the material above complies with the following specifications:

AMS 4027	ASTM-B209		
	ROHS COMPLIANT		
QUANTITY UOM VENDOR	VEND PO HEAT/LOT	PCS : TAG NO	QUANTITY UOM VENDOR
52.00 LB CORUS	OCC1837 7124901		VEND PO HEAT/LOT

M100792

General Manager: TORONTO

PRINTED 04/19/06 03:02 PM

CONTROL NO 00049

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